Work Order I April-30-13 2:49:28		109		*101	109*							Page	1
Revision ID: Item Name: Stra Start Date: 4/30 Required Date: 4/30	0/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N900 Cust Item Customer	ID:	100)*	Setup	Start Stop	į N	S1* S2*	
		:_HLJ	Date: 13-05-0			Date:			Run	Start Stop	!Л	R1* R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revis	ion Nbr											market a second
D2324	Rev C	,											
100 *100* Waterjet FLOW CNC Waterjet 304 - 063	,	FLOW WATER JET Memo 1-Cut as pe Deburr if no	r Dwg D2324 Dwg Rev:	0.00 0.00 Prog Rev: C	22-			\$			(DAS 05	13.05.
*110 .	•	QC2- Inspect parts off n	nachine FAI/FAIB	0.00				0				QAS 05	10 %
QC Quality Control		Memo		0.00								. <u> </u>	13.05.
120 *120* QC Quality Control	,	QC8- Inspect parts - sec	ond check	0.00 23	S			8					

											DQA:	Date:	
NCR: Y	es/	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPDATE		QA Closed:	Date:	
*						1				•			
Work Orde	er:			•		DISPOSITION			AG	PARTMENT,	PROCESS		
	_					Rework]		Skid-tube Cro	sstube		Water Jet	Engineering
Part N	lo					Scrap			Ŭ	all Fab		d. Eng. Coor.	Quality
NCR N	NCR No.					Use-as-is Work Order Update				Rec/Stor	e/Packaging Supplier	Other	
Root	Root Descr					ption of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	tep Qty or Non-conformance			Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data	_												
Equip/Tooling													
Operator													
Material				ŀ									
Setup [
Other									,				
Process													
Supplier													
Training [
Unapproved													
						F	AUL	T CATE	GORY				
Landir	ng G	ear				General					•		•
	Bending			Bend		Grain			Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S BOM				BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspection Incomplete				Part Incorred	Weld		
Ţ	Crushed/Crimped					Burrs	Instructions Incomplete/Unclear			Part Lost/Mi	ssing	Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Orde		01109	· · · · · · · · · · · · · · · · · · ·	*101				Page 2				
Item ID: Revision ID:	D2324-5			Accept	*N900	<u>040</u>	100) * s	Setup S	start	*N	S1*
Item Name:	Strap		. (•	\$	Stop	*N!	S2*
Start Date:	4/30/13	Start Qty: 8.00	*8*	,	Cust Item l	ID:						
Required Date: Reference:	4/30/13	Req'd Qty: 8.00	*8*		Customer:							
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ate:		R		Start Stop	*N! *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Sto	ock Location	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
130 Packaging Packaging		Мето	<u></u>	0.00				XX	. ——			3-5-1
140		QC21- Final Inspection -	Work Order Release	0.00								
140 QC		Memo		0.00				· · · · · · · · · · · · · · · · · · ·	·			
Quality Control										N	ルンゴ	13-05-15

											DQA:	Date	
NCR:	es /	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:	Date	
			-i - =			DISPOSITION		i		AGAINST DE			•
Work Orde	er:				<u> </u>		.			· · · · · ·	1		.
						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No. —					Work Order Update		Large Fab	Composite		Supplier		
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	c	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							ì						
Operator													
Material						1							
Setup							1						
Other													
Process													
Supplier													
Training													
Unapproved				<u> </u>									
						F	AUL	T CATE	GORY				
Landi	ng Ge	ar				General	_				7	-	7
	В	ending				Bend		Grain		<u> </u>	Ovalized	L	Pressure/Forced
	∐c	entre No	t Concer	ntric to	o/s	BOM/Route		Hardwa			Over/Under	-	Temperature/Cure
		racks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	c	rushed/0	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		uffs				Contamination		Mainte	nance		Part Moved		
	Шн	leat Trea	t			Countersink		Mislabe	led		Positioned V		_
	L li	nspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
	R	ipples in	Bend			Drill Holes	Offset						
	Т	Torque Waves in Extrusion				Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

April-30-13 2:49:28 PM

Work Order ID:

Parent Item Name:

101109

Parent Item:

D2324-5

Strap

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP E03.02.28Reformat; Incorporated D2324-3 & D2324-5KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	268.4214	0.0184	0.1472	<u></u>	<u> 13.</u> 05	:15
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		268.4213688				<u> </u>			
				1222	45	0.1713688							
				1231	36	140.8							
				1244	28	29							
				1245	72	98.45							

											DQA:	Date:	
NCR:	Yes /	No No				WORK ORDER NON-	COI	NFOR	MANCE / UPDATE		•		
											QA Closed:	Date:	
Morle Orde						DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	
Work Orde	er:					Rework	ר	Skid-tube Crosstube			1	Water Jet	Engineering
Part N	No.					Scrap	1		 i	l Fab	Pro	d. Eng. Coor.	Quality
10111	•••					· — •			~ —	shing	4	re/Packaging	Other
NCR N	NCR No.					Work Order Update Large Fab Composite					Supplier		
											_		
Root		•				ption of work order update	1	Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data	Ш										<u> </u>		
Equip/Tooling	Щ												
Operator	Ш												
Material													
Setup	Ш												
Other	Ш						1						
Process	Ш												
Supplier	Ш						1						
Training	Ш						1						
Unapproved							<u> </u>						
			 				AUI	LT CATE	GORY				
Landi						General		1		<u> </u>	1		1
	Bending					Bend	-	Grain		-	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	-	Hardwa		-	Over/Under	 	Temperature/Cure
	Cracks					Broken/Damaged	<u></u>	-1 '	on Incomplete	-	Part Incorred		Weld
	Crushed/Crimped					Burrs	-	4	ions Incomplete/Unclear	-	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination	\vdash	Mainte		<u> </u>	Part Moved		
1	H	eat Trea	t		ļ	Countersink	1	Mislabeled			Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	101109
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing	Talamana	Actual		D : .	Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
R0.38	+/-0.030	R0.38	\checkmark		RG	
Ø0.257	+0.006/-0.001	0.257	1		V	JKM-01
Ø0.191	+0.005/-0.001	0.193	1		V	O BI
0.750	+/-0.010	0.755	✓		V	
0.375	+/-0.010	0.377	1		V	
1.875	+/-0.010	1.872	\checkmark		V	
3.000	+/-0.010	2.996	\		V	
3.375	+/-0.010	3.373	\int		7	
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		<u>. </u>	OAn.	i		

Measured by: N/N Audited by: Res Prototype Approval: N/A

Date: 13.05.15

Date: /// Date: N/A

Rev.	Date	Change		Revised by	Approvéd
Α	06.06.05	New Issue		KJ/JLM	
			······································	· · · · · · · · · · · · · · · · · · ·	



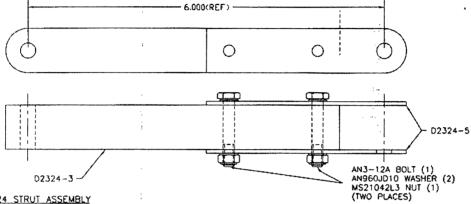
DESIGN B WILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED	APPROVED	DRAWING NO. D2324 . SHEET	REV.	_
DATE	13	TITLE	SCAL	Ξ
04.12.14		STRUT		
	^			

 04.12.14
 STRUT

 A
 94.11.08
 NEW ISSUE

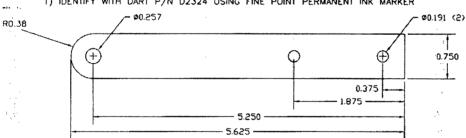
 B
 96.05.07
 UPDATE MATERIALS

 C
 04.12.14
 UPDATE NOTES



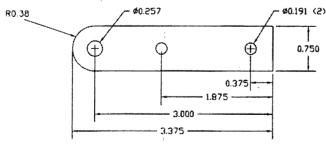
D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3 1) MATERIAL:

- AL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
 - (REF DART SPEC. M6061T680.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



02324-5

- 1) MATERIAL: AISI-304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP CHPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITH CLE NOTICE

WO TO THE ABOUT

NO.-1-0-1 LOT MOSTO!